

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006204**Date Inspected:** 07-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG outside assembly

This QA observed that the contractor has performed material straightening without an approved straightening procedure. The contractor has attempted to straighten the deck plates on OBG segments by tack welding temporary stiffeners to the top side of the deck plates in the area of the crossbeams. The OBG segments and deck plates are identified as OBG segment 3AW deck panel DP011A, OBG segment 4BW panel DP047A and OBG segment 3AE panel DP012A. AWS D1.5 2002 section 3.1.5 prohibits welding on the material if no weld is detailed on the drawings and 3.7.3 requires engineers approval prior to straightening material distorted by welding. This QA notified ZPMC QA identified as Mr. Wang Lu and ABF QA inspector identified as Mr. Kelvin Cheung that an incident report would be forth coming concerning this issue.

OBG bay 5

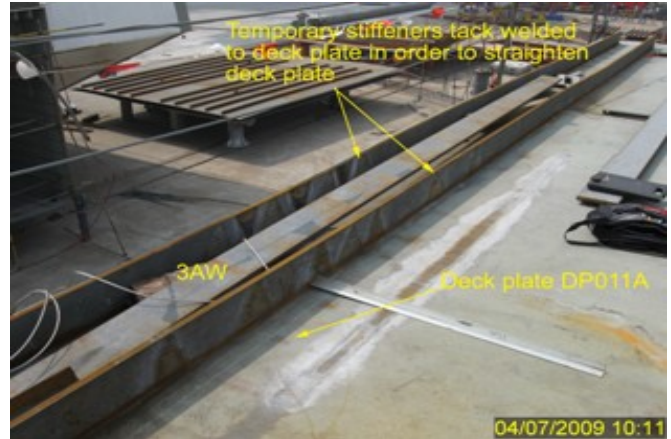
This QA observed that the contractor has deviated from the weld joint design on the following welds by adding steel backing without engineers approval: FB204-001 welds 53, 57, 66, 69, 59, 60, 63, 64, FB204-002 welds 49, 50, 53, 60, 57, 58, 69, 70, 66, FB-204-003 welds 49, 50, 54, 57, 58, 88, 69, 70, 59, FB-204-004 welds 49, 50, 57,

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60, 59, 64, 63, 65, 53, 54, 69, 70, FB-205-002 weld 26, FB-205-003 welds 32, 25, 26, FB-205-004 welds 29, 30, 31, 32, 36, 26. This QA notified ZPMC QA identified as Mr. Wang Lu and ABF QA inspector identified as Mr. Kelvin Cheung that an incident report would be forth coming concerning this issue.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
